

**Garant**
**Solid carbide milling cutter TPC, uncoated, Ø h6 DC: 8mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 202281 8      |
| GTIN         | 4045197773296 |
| Item class   | 11X           |

**Description**
**Version:**

**Eccentric relief ground**, additionally **polish ground** in the flutes for **outstanding chip evacuation** in long-chipping aluminium workpieces.

With double chip-breaker for exemplary chip formation.

**Note:**

$a_{e \max} = 0.12 \times D$  for TPC machining.

$h_{\max}$ : The values stated in the table are maximum values.

**Technical description**

|                                 |                                  |
|---------------------------------|----------------------------------|
| Shank                           | DIN 6535 HA to h6                |
| Flute length $L_c$              | 33 mm                            |
| Recess $\varnothing D_1$        | 7.4 mm                           |
| Tolerance nominal $\varnothing$ | h6                               |
| Shank form                      | HA                               |
| Shank $\varnothing D_s$         | 8 mm                             |
| Balance quality with shank      | G 2.5 with HA                    |
| No. of teeth Z                  | 3                                |
| Corner chamfer width at 45°     | 0.2 mm                           |
| Overall length L                | 80 mm                            |
| Direction of infeed             | horizontal, oblique and vertical |
| Cutting edge $\varnothing D_c$  | 8 mm                             |

|  |                         |
|--|-------------------------|
| Overhang length $L_1$ incl. recess   | 40 mm                   |
| Average chip thickness $h_{max}$ for TPC milling in short-chipping aluminium | 0.043 mm                |
| Helix angle  | 45 degrees              |
| Corner chamfer angle   | 45 degrees              |
| Coating  | uncoated                |
| Tool material  | Solid carbide           |
| Standard   | Manufacturer's standard |
| Type   | W                       |
| Helix angle characteristic   | unequal spacing         |
| Cutting width $a_e$ for milling operation                                    | $0.12 \times D$         |
| Through-coolant  | no                      |
| Machining strategy   | TPC                     |
| Colour ring  | yellow                  |
| Type of product  | End / face mill         |

## User data

|                            | Suitability                               | $V_c$     | ISO code |
|----------------------------|---|-----------|----------|
| Aluminium                  | Suitable                                  | 130 m/min | N        |
| Aluminium (short chipping) | suitable                                  | 100 m/min | N        |
| Alu > 10% Si               | suitable                                  | 85 m/min  | N        |
| PMMA acrylic               | suitable                                  | 125 m/min | N        |
| PE-HD                      | Suitable                                  | 90 m/min  | N        |
| PA 66                      | Suitable                                  | 100 m/min | N        |
| PEEK                       | suitable                                  | 80 m/min  | N        |
| PF 31                      | Suitable                                  | 70 m/min  | N        |
| Honeycomb sandwich         | suitable only under restricted conditions | 100 m/min | N        |
| Cu                         | Suitable                                  | 70 m/min  | N        |

|                        |   |          |           |
|------------------------|---|----------|-----------|
| CuZn                   | Suitable                                  | 90 m/min | N         |
| wet maximum            | suitable                                  |          |           |
| wet minimum            | suitable                                  |          |           |
| dry                    | suitable only under restricted conditions |          |           |
| Air                    | suitable only under restricted conditions |          |           |
| <b>Services</b>        |   |          |           |
| Shank grinding Type HB |   |          | 129100 HB |